

Date: Thursday, 24/07/2008 8:23:49 AM  
 User: Melanie Fauteux

## Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY  
 Job Number : 40608-2  
 Estimate Number : 13433  
 P.O. Number :  
 This Issue : 24/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 17/07/2008 Type : LARGE FAB ASSY  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 08-07-24  
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB674300115  
 Drawing Number : B6743001 P.7  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 24/07/2008 Qty: 3/ Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 40585

MF 08-07-24 5

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: m12141

MF 08-07-24 5

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045

MF 08-07-24 5

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

MF 08-07-24 5

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71

batch: 340027

MF 08-07-24 5

Hteli



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Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*Handwritten:* 08-07-24 5

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 08-01-29(5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 08-07-29(45)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT

*Handwritten:* M 17935

*Handwritten:* 08-07-30

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

*Handwritten:* BR 08-07-30

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 08-07-30 (13)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* u/a S.

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*Handwritten:* M102316

*Handwritten:* (5X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*Handwritten:* m-h 08/07/31





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Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40 OF  
320 °F  
2:10

MP 08/07/31  
(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31  
(5)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
20 Degree Cover Plate  
batch: 40094

FL 08.08.26 5

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
PB67-43001-83  
batch: 40096

FL 08.08.26 5

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Screw  
batch: 108986

FL 08.08.26 5

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)  
WASHER  
batch: 108173

FL 08.08.26 5

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- match drill cover to existing holes in support  
2- assemble as per dwg

FL 08.08.26 5



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Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (83)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

39952

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08-08-26







